Work Order January-28-13 12:		-	*964	162*							Page 1
Revision ID:	3022-1		Accept	*N900	040	100	<b>)*</b> s	Setup	Start Stop	*N	S1*
	28/13 Start Qty: 1.00 12/13 Req'd Qty: 1.00	•		Cust Item I Customer:	D:				зюр	*N;	S2*
	Process Plan:M_5QC:		Tooling: _ SPC (Y/N):		ate:		F		Start Stop		R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject lumber	Insp. Stamp
Draw Nbr	Revision Nbr	<del></del>							-		
D3022	Rev B										
*100 *100* Waterjet  FLOW CNC Waterjet	Dwg Re		0.00				(	٥			Jm13-4-15
2024 .033	*** gri **NO H 2-Debur	nd direction along 31.700" *** OLES,TRANSFER DRILLED r if necessary  ff machine FAI/FAIB	AT ASSEMBLY***  0.00								
*110*	Memo		0.00						9		Jm 3-4-1

Quality Control

NCR: Y	es /	No			WORK ORDER NON-	COI	<b>NFORM</b>	ANCE / UP	DATE		·			
											QA Closed:		ate:	
Work Orde	ır.				DISPOSITION				AGAINST I	DΕ	PARTMENT	PROCESS		
Part N	 lo				 Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube  Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		4	Water Je d. Eng. Coo re/Packagin Supplie	r	Engineering Quality Other
NCR N	···.—				 Work Order opdate	ٔ ل		carge ran	Composite		J	Juppin	-'	
Root Cause		Date	Step	Qty	ption of work order update or Non-conformance		Initial nief Eng		tion ription		Sign & Date	Verificat	ion	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								•				,		
					<del></del>	AUI	T CATE	GORY				<del>.</del>		
Landir	Be Ce Cr Cr Cr He In	ending entre No racks rushed/G uffs eat Trea spection pples in	Strip in	Tube	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ nance led	Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

Folio

Work Order January-28-13 12:		2		*964	162*							Page 2	
Revision ID:	3022-1 at Pan			Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	1/1.	S1*	
	28/13 Sta	art Qty: 1.00 eq'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				-	"IV.	S2*	
Approvals: P			Date:	_ 0 =		ațe: ate:	- 		Run	Start Stop	1/1	R1* R2*	
Sequence ID/ Work Center ID  120 *120* QC	Des	eration scription 8- Inspect parts - seco Memo	nd check	Set Up/ Run Hours 0.00 AS 27 9-69	Tool ID	Tool #	Plan Code	Accept Qty	t Re Qty		Reject Number	Insp. Stamp	
Quality Control  130  *120*  Brake NC  Brake NC	Ben	nd as per dwg Memo		0.00 0.00	<b>∕</b> ∕			_1				S/- 	3
140 <b>*1111 1 1 1 1 1 1 1</b>	QC	5- Inspect part comple Memo	teness to step on W/O	0.00 37	<b>3</b> 73								

Quality Control

NCR:	Yes	/ No				WORK ORDER NON-O	O	NFOR	MANCE / UP	DATE		•		•	· · · · · ·
												QA Closed:	Da	te:	
Work Orde	or.					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
Part N	- No					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	1	nitial	Act	tion		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desci	ription		Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved									••			·			
						F.	AUL	T CATE	GORY						
Landi		Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection	Crimped, t n Strip in		O/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misread	ion Incomplete tions Incomplete/ enance eled	Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	1	Ripples in	Bend		ł	Drill Holes	1	Offset							

Out of Calibration
Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

<b>Work Ord</b>	er ID	96462
January-28-13	12:32:32	PM

Quality Control

## \*00460\*

Page 3

January-28-13				"9h4	In/"						Tage 5	<u>=</u>
Item ID: Revision ID:	D3022-1			Accept	*N900	<b>040</b>	100	<b>)*</b>	Setup Sta	rt *N	S1*	
Item Name:	Seat Pan								St	<sup>op</sup> *N	S2*	
Start Date: Required Date	1/28/13 · · · · · · · · · · · · · · · · · · ·	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:						
Reference:							-	T	Run Sta	art **		
Approvals:	Process Pla	an:	Date:	_ Tooling: _ _ SPC (Y/N):		ite:		,	St St	I <b>/</b> I	IR1* IR2*	
Sequence ID/ Work Center I	D	Operation Description Identify as per dwg & St	ock Location: WAG	Set Up/ Run Hours  0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
*200* Packaging Packaging		Memo		0.00				_W_			13-49	)[
210		QC21- Final Inspection	- Work Order Release	0.00					ſ	3/4/	but	<b>ハ</b>

0.00

Memo

NCR ·	Yes	1	No

DQA: Date:

NCR: Y	'es / No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE	QA Closed:	Date:	
Work Orde	ar:				DISPOSITION			AGAINST	DEPARTMENT,	/PROCESS	
Part N				· · · · · · · · · · · · · · · · · · ·	Rework Scrap Use-as-is	Ther	Skid-tube Machining moforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	10				Work Order Update		Large Fab	Composite		Supplier	
Root					ption of work order update	Initial	1	tion I	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	ription	Date	Verification	QC Inspector
Doc/Data								i			
Equip/Tooling								I			
Operator							1	l			
Material		1						1			
Setup		ļ						Į.			
Other								4			
Process								ì	ļ		
Supplier						1		1			
Training		ŀ						1			
Unapproved	<u> </u>		<u> </u>			AULT CAT	 FGORY	· · · · · · · · · · · · · · · · · · ·		<u> </u>	
Landi	ng Gear			-	General			1			
	Bending				Bend	Grain		· [	Ovalized	Γ.	Pressure/Forced
	<b>—</b>	Not Conce	ntric to (	o/s	BOM/Route	Hardw	rare	,	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspec	tion Incomplete	,	Part Incorre	ct	Weld
	<del></del>	/Crimped	_		Burrs	Instru	ctions incomplete/	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs	•			Contamination	Main	enance	,	Part Moved		_
	Heat Tre	eat			Countersink	Mislak	eled		Positioned V	Vrong	
	Inspecti	on Strip in	Tube		Cut Too Short	Misre	ad	1	Power Loss/	Surge	Other
	Ripples				Drill Holes	Offset		1			
	Torque	Waves in I	Extrusion	n	Drawing	Out of	Calibration	1			
	Turning	Sequence			Finish	Out of	Sequence	Į.			
	Wave/T	wist in Tul	be		Folio	Outsid	le Dimensions	1			

## **Picklist Print**

January-28-13 12:32:31 PM

Work Order ID:

96462

Parent Item:

D3022-1

Parent Item Name:

Seat Pan

**Start Date:** 1/28/13

Required Date: 2/12/13

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP C02.01.23Revised NO

IPP Rev:D 08-04-16 now water jet DD verified by:EC

IPP Rev:E 08-12-18 as per ECN08-582 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	370.1522	1.6232	1.7086316			7. 7 4
2024-T3 .032 sheet									- 7 M M	1.75		<del>_</del> _ <del>_</del>	Jm 13-4
				<b>Location</b>		Loc Qty	<u>Lo</u>	c Code					
				MAT022		370.1522							
				118	243	32.4962							
				118	523	141							
				121	309	68.656							
				123	096	27.6							
				123	574	100.4			_i2	<u> 3574</u>			

												DQA:	Da	ite:	
NCR:	/es	/ No				WORK ORDER NON-O	O	NFORM	AANCE / UP	DATE		OA Classal	D-		
												QA Closed:	Da	ite:	
Monte Onde					·	DISPOSITION				AGAINST [	Œ	PARTMENT	PROCESS		
Work Orde	: T .					Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	۷o.					Scrap	1	1	Machining	Small Fab		Pro	d. Eng. Coor.	$\vdash$	Quality
						Use-as-is	1	Therm	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	No.					Work Order Update	]		Large Fab	Composite			Supplier		
Root		· · · · · ·			Descri	ption of work order update		Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling						•			•						
Operator			}									ĺ			
Material												<u> </u>			
Setup															
Other			ļ												
Process					•										
Supplier												<u> </u>			
Training															
Unapproved					ļ.,	·····							<u></u>		
						F	AUI	LT CATE	GORY						
Landi	ng (	Gear				General	_	-		-		7		_	T .
	L	Bending				Bend	$\perp$	Grain				Ovalized		$\vdash$	Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re	ļ		Over/Under	tolerance	<u>_</u>	Temperature/Cure
į		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre		L	Weld
		Crushed/	Crimped			Burrs		-	ions Incomplete/	Unclear		Part Lost/M	issing		Wrong Stock Pulled
		Cuffs				Contamination	_	Mainte	nance			Part Moved			
		Heat Trea	at			Countersink		Mislabe	led			Positioned V	_	_	٦
		Inspectio	n Strip in	Tube		Cut Too Short	L	Misread	i			Power Loss/	Surge	L	Other
		Ripples in	Bend			Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

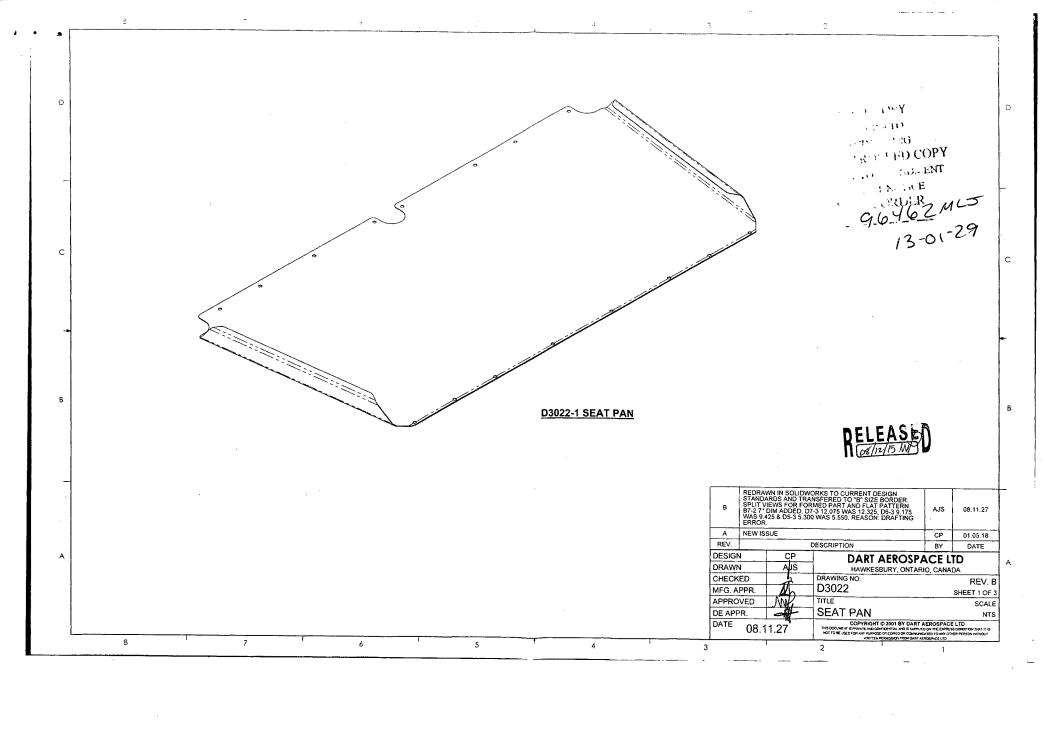
DART AEROSPACE LTD	Work Order: 9646	2
Description: Seat Pan	Part Number: D36	022-1
Inspection Dwg: D3022 Rev: B	Page	1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing		Actual		1	Made	
Dimension	Tolerance	Dimension	Accept	Reject	Method of inspection	Comments
14.75	+/-0.030	14.75	-		T	Jenob
12.28	+/-0.030	D.28°	_		T	
2.72	+/-0.030	2.72	_		V	Jimos
14.62	+/-0.030	14.62"	_		丁	Je we
12.15	+/-0.030	13:12	-		T	
					31/M/M-2	

OA.					
Measured by:	Jm	Audited by:	27	Preliminary Approval:	
Date:	13-4-15	Date:	13 4 16	Date:	

Rev	Date	Change	Revised by	Approved
_ A	08.06.13	New Issue	KJ/DD IN	7//
В	11.06.21	Dwg Rev updated	KJ W	
			· · · · · · · /   -	



96462

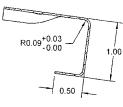
D

С

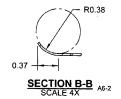
Ac2-2 B Ф SYM ABOUT



D3022-1 SEAT PAN B



SCALE 4X



DESIGN	CP	DART AEROSE	PACELTD
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO.	RÉV. B
MFG. APPR.	$M_{\Omega}$	D3022	SHEET 2 OF 3
APPROVED	MA	TITLE	SCALE
DE APPR.	-81	SEAT PAN	NTS
DATE 08.11.27		THIS DODALENT IS REMAINED AND THE STREET OF	

NOTES:
1) MATERIAL: MAKE FROM D3022-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NA
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3022-1" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 1.36 lbs

8

5

В

